

# Work Order ID 52098

September 16, 2009 10:09:18 AM

Page 1

Item ID: D3954-5

Accept

Setup Start

Revision ID: A

Stop

Item Name: Chain Lug

Start Date: 09/16/2009 Start Qty: 2.00

Required Date: 09/25/2009 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-09-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

mill to size

09.09.30

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: A

Prog Rev: A


2-Deburr if necessary

09.09.30

110

W/O: 52098

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	110	0.750 max hole is 0.762 acceptable as is.	ASS	09.10.02	6	ASS 	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## NCR: WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

*09.16.01*

QC

Memo

0.00

*6*

Quality Control

130

QC8- Inspect parts - second check

0.00

*SA 09/10/02*

QC

Memo

0.00

*6*

Quality Control

140

Identify as per dwg & Stock Location *1390*

0.00



Packaging

Memo

0.00

*9/16/2* *605*

Packaging

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop



Item Name: Chain Lug

Start Date: 09/16/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13 *[Signature]*  
MF  
09-10-08

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

September 16, 2009 11:18:22 AM

Page 1

Work Order ID: 52098



Parent Item: D3954-5RevA



Parent Item Name: Chain Lug

Start Date: 09/16/2009

Required Date: 09/25/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	14.2900	2.1053			
<del>M304B1.500X1.500</del>												

18 9-9-30

M1010 - M1020

See Dwg 9-16-09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	14.29	
108381	14.29	
<del>110386</del>		
110368		

110386

1" x 12"

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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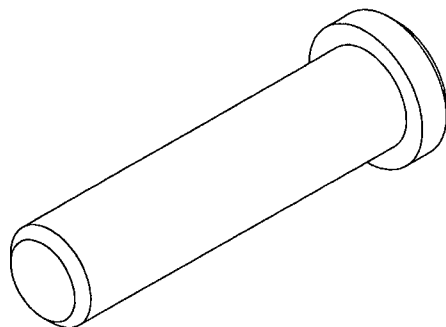
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

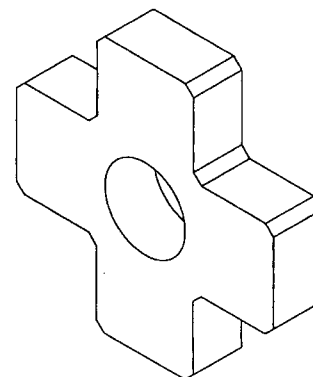
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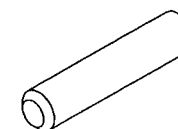


**D3954-1 GWT PIN**

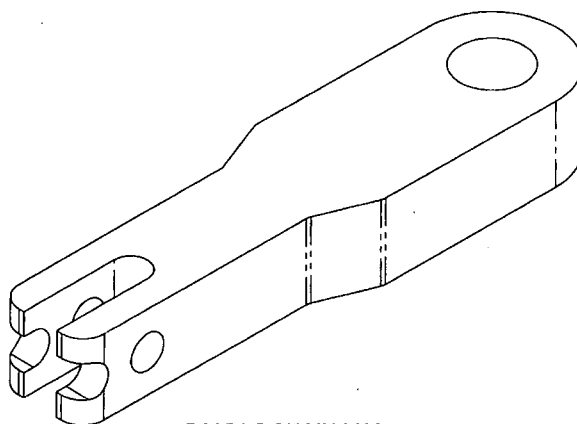


**D3954-3 GWT KNOB**

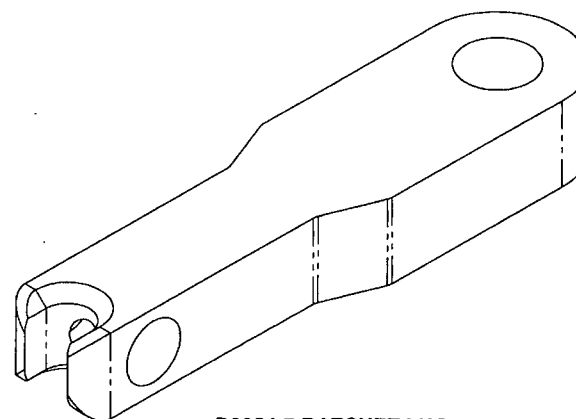
*52098*



**D3954-9 GWT CHAIN PIN**



**D3954-5 CHAIN LUG**



**D3954-7 RATCHET LUG**

**RELEASED**  
*09/05/26*

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	09.05.26
DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3954	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.05.26	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

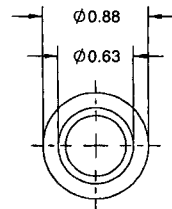
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

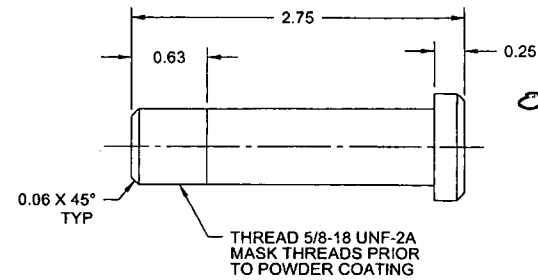
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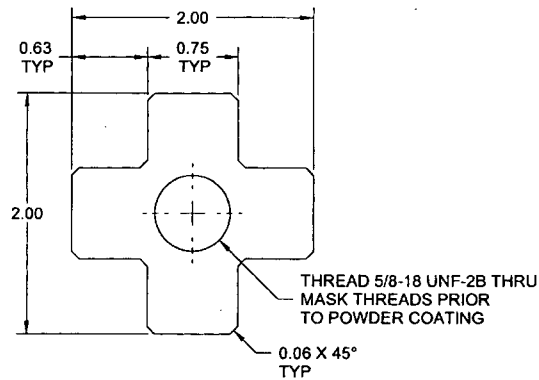
**NOTE:** Date & initial all entries



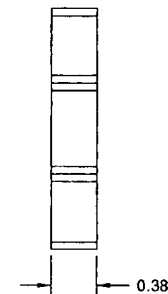
**D3954-1 GWT PIN**



#52098  
okay mild Steel  
ASS  
09.09.28



**D3954-3 GWT KNOB**



**NOTES:**

1) MATERIAL -1: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET  
PER AMS 5513 OR AMS 5524  
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs  
-3: 0.23 lbs

**RELEASED**  
09/16/12

DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3954</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	<b>MISC MACHINED PARTS GWT KIT</b>	
DATE	09.05.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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